

Black for 501101889

Work Order ID 58257

Monday, May 03, 2010 8:59:13 AM

Page 1

Item ID: D3914-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2010 Start Qty: 1.00

Required Date: 5/7/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-5-3

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: M113328 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914

10/05/12 (1K) AS →

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

10.05.12

NCR: 58257		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/11	# 100	After welding lid empty in new DT 1607A employee noticed that there was D4035-041 used D4035-043 were not in the correct Sides of Basket Lid mounting to the D4016-3 support mounting brackets		- Remove the existing brackets & grind the welds flush. - Ensure the lid is in the correct orientation & weld	N/A misinformd			S 10/05/11
		Rt. empty welder wasn't paying attention to new sig. and design		on new D2581 & D4016-3 lugs per the drawing. part is S.S. & will not be affected by re-welding.				/1005-11
				-Remove D4035-041 and D4035-043 Scrap them Replace with new one and weld in correct place	 10/05/12	 10/05/12		

H:\FORMS\Quality Assurance\approved QA\NCRW0 RevE

B4035-041 Batch: B58192
B4035-043 Batch: B58193

Work Order ID 58257

Monday, May 03, 2010 8:59:13 AM



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Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Long Basket Lid Assembly (350)				Stop	
Start Date:	5/3/2010	Start Qty:	1.00			
Required Date:	5/7/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
	<i>* Fit is very tight to Box</i>	0.00							
QC	Memo								
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
	<i>M 10-5-642</i>	0.00							
Powdercoat	Memo								
Powder Coating									
140	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
	<i>114432</i>	0.00							
HandFinish	Memo								
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg								
	2- Install placard and label as per dwg								

① BR 10-5-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58257

Monday, May 03, 2010 8:59:13 AM



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Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

EB 5/10/05/13 *Q*

160

Identify as per dwg & Stock Location: *GA*

0.00

Packaging

Memo

0.00

Packaging

w/o 58313

EB 5/10/05/13

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

1005-14
WME 10-5-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 8:59:12 AM

Page 1 / 3

Work Order ID: 58257

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/3/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

27.0000

2



Mounting Bracket



SY 10/05/11

Location

Loc Qty

Loc Code

WA

27

46086

2

51745

2

57185

23

D2728-3

Manufactured

No

140

Each

0.0000

1



Dart Logo label

D3914-1

Manufactured

No

100

Each

0.0000

2



Rib

D3914-7

Manufactured

No

100

Each

2.0000

2



Rib



B58241 @ SY 10/05/11

B58242 @ SY 10/05/11

Location

Loc Qty

Loc Code

WA

2

57573

2

D4016-3

Manufactured

No

100

Each

13.0000

3



Hinge Half, Lid



SY 10/05/11

Location

Loc Qty

Loc Code

ST109

12

57574

12

WA

1

56950

1

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 8:59:12 AM

Page 2/3

Work Order ID: 58257



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2010

Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

✓ D4018-5 		Manufactured	No			100	Each	0.0000	9		B58244 ⑨	10/05/11
---------------	--	--------------	----	--	--	-----	------	--------	---	--	----------	----------

✓ Rib D4020-5 		Manufactured	No			100	Each	1.0000	1		B58245 ①	10/05/12
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Mesh (350 Basket Long, Lid)

Location Loc Qty Loc Code

WA 1
58041 1

✓ D4021-3 		Manufactured	No			100	Each	2.0000	1		B58246 ①	10/05/11
---------------	--	--------------	----	--	--	-----	------	--------	---	--	----------	----------

Data Plate

Location Loc Qty Loc Code

WA 2
56050 1
57109 1

✓ D4035-041 		Manufactured	No			100	Each	1.0000	1		B58192 ①	10/05/11
-----------------	--	--------------	----	--	--	-----	------	--------	---	--	----------	----------

Lid Rib Assembly, Fwd (350 Basket)

Location Loc Qty Loc Code

WA 1
57575 1

✓ D4035-043 		Manufactured	No			100	Each	1.0000	1		B58193 ①	10/05/11
-----------------	--	--------------	----	--	--	-----	------	--------	---	--	----------	----------

Lid Rib Assembly, Aft (350 Basket)

Location Loc Qty Loc Code

WA 1
56983 1

Monday, May 03, 2010 8:59:12 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 8:59:12 AM

Page 3

Work Order ID: 58257



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2010

Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4086-210

Manufactured

No

140

Each

8.0000

1



Placard, Max Load

Location

Loc Qty

Loc Code

ST112

8

56978

8

EP 5/05/13

1

Monday, May 03, 2010 8:59:12 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

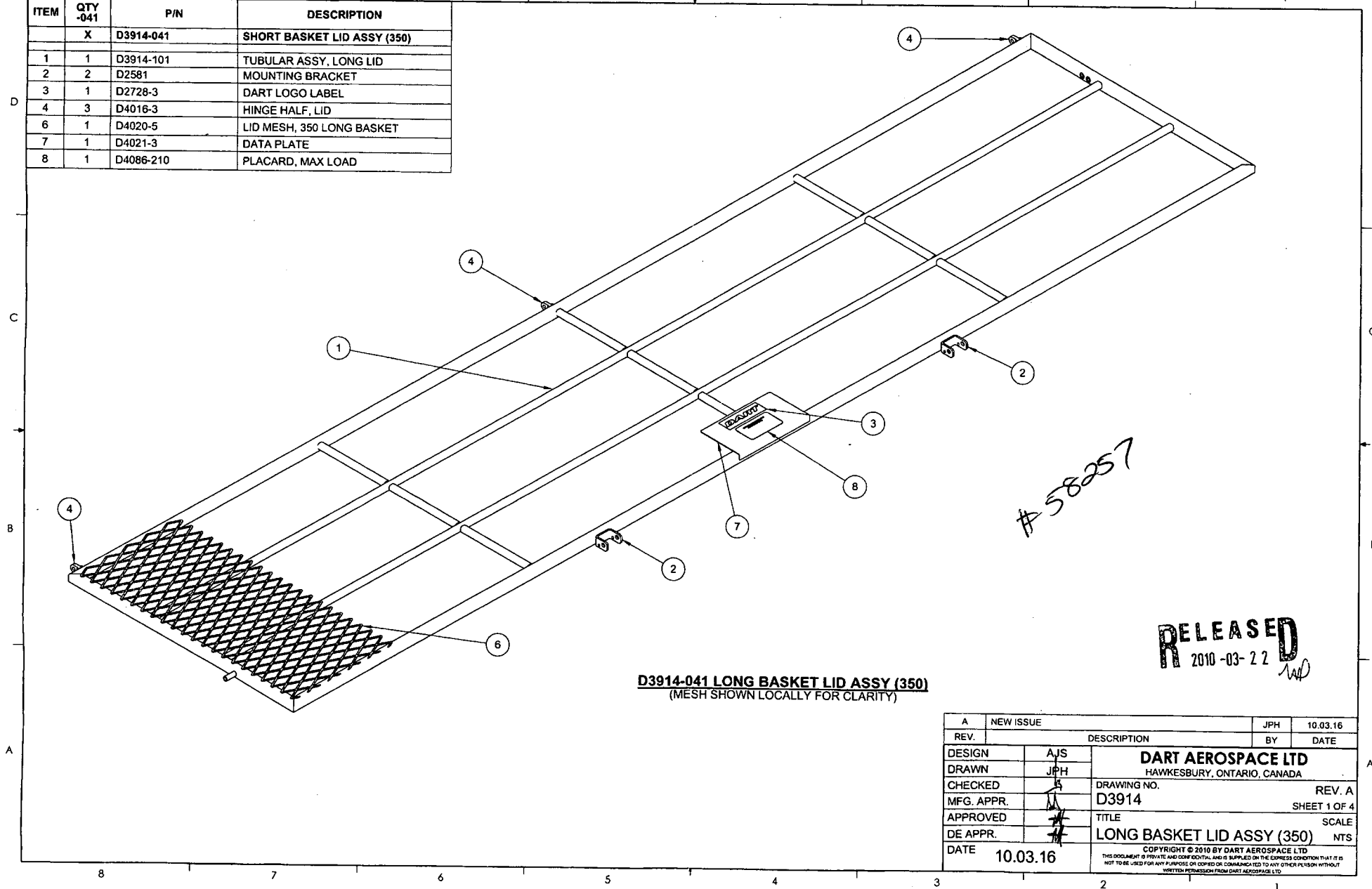
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



RELEASED
2010-03-22

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	IS	DRAWING NO.	REV. A
MFG. APPR.	IS	D3914	SHEET 1 OF 4
APPROVED	IS	TITLE	SCALE
DE APPR.	IS	LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

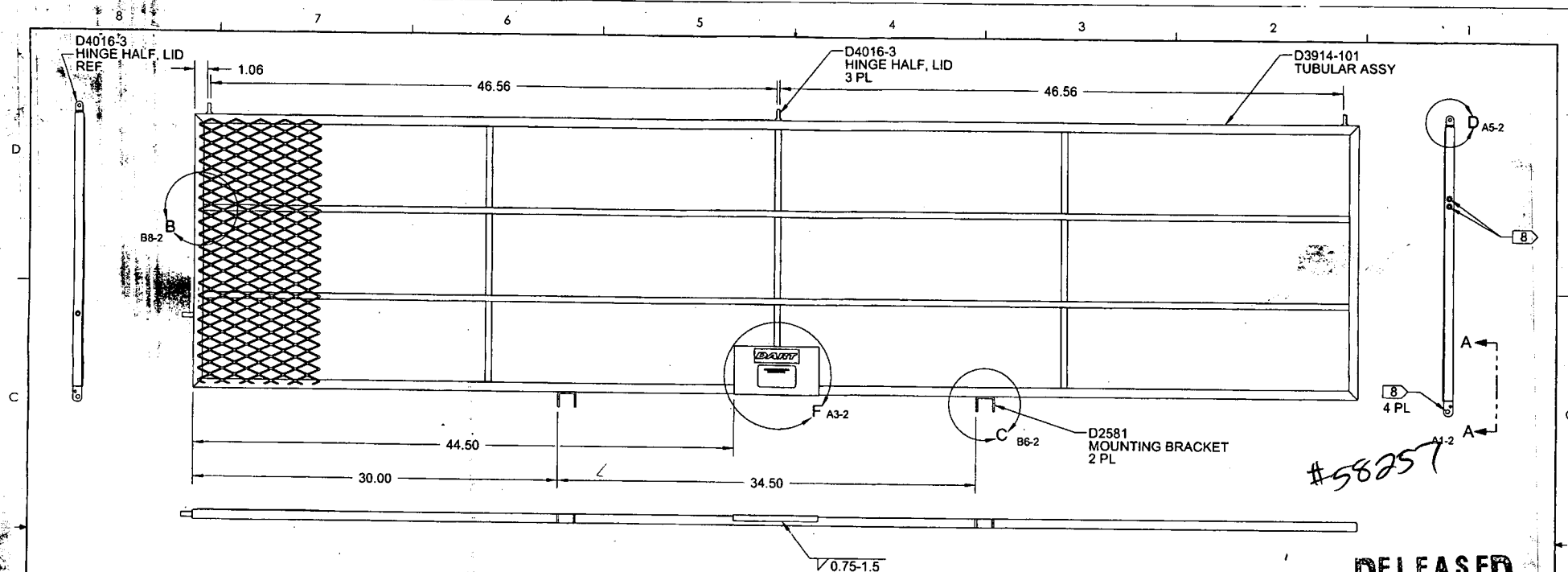
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

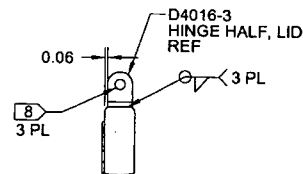
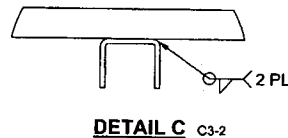
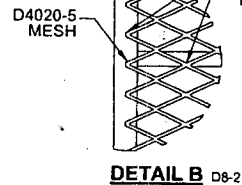
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

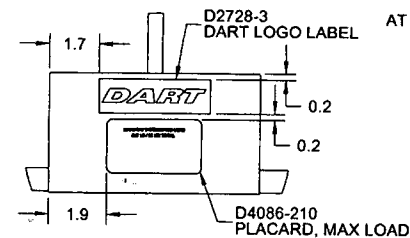


D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

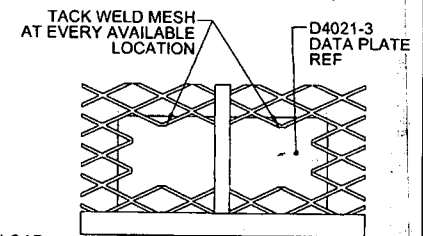
TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



DETAIL D D1-2



DETAIL F C4-2



VIEW A-A C1-2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV A
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
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RELEASED
2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

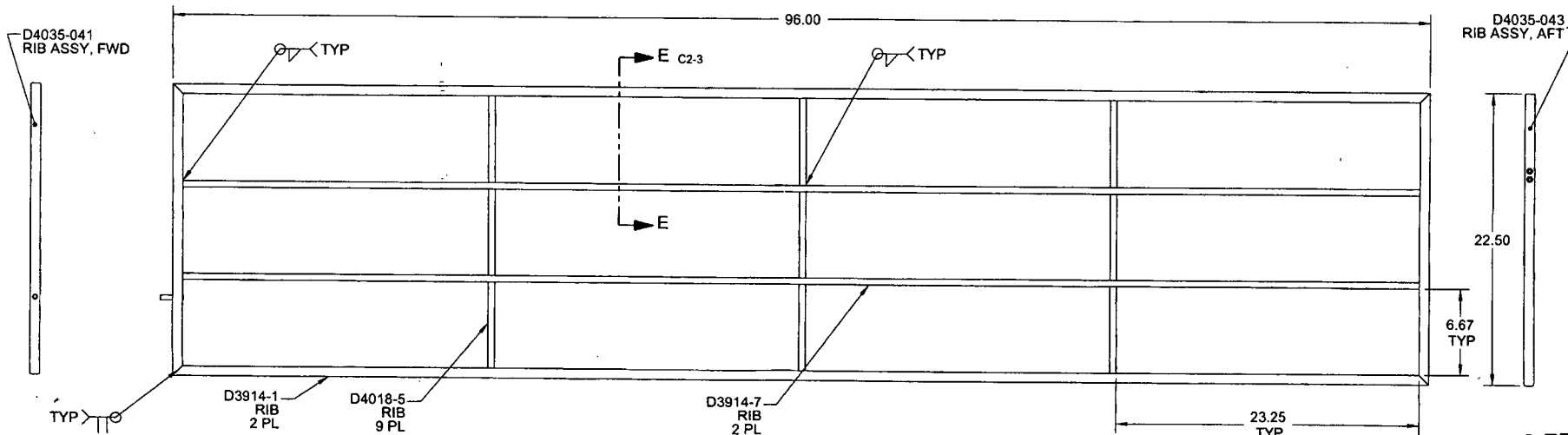
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
2010-03-22
AWP

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DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 3 OF 4
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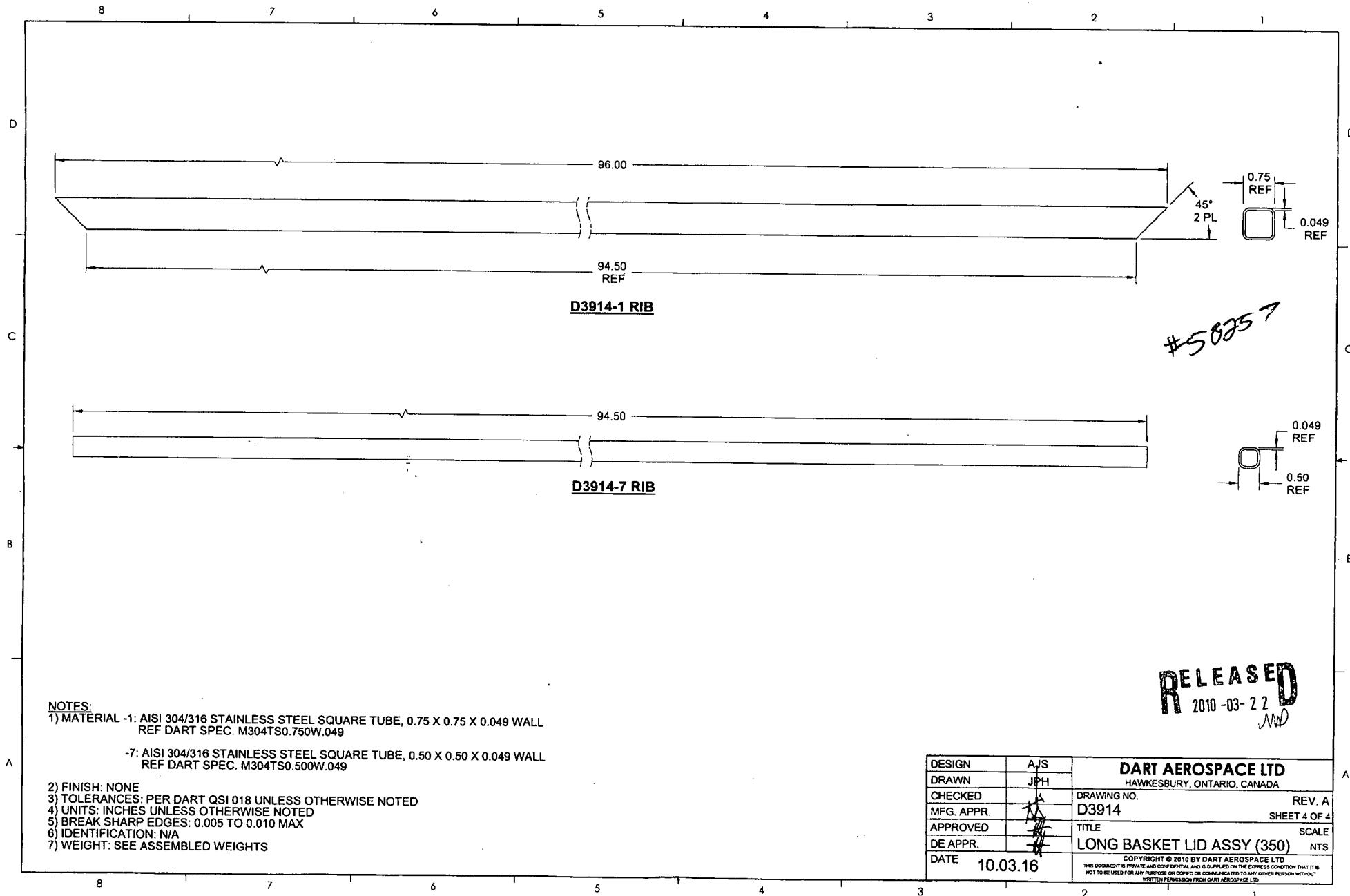
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